

Date: Wednesday, 02/04/2008 11:27:30 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services				Drawing Name	: BRACKET	
Job Number	: 38296				Part Number	: D35421	
Estimate Number	: 12840				Drawing Number	: D3542 REV A	
P.O. Number	:				Project Number	: N/A	
This Issue	: 02/04/2008 S.O. No. :				Drawing Revision	: A	
Prsht Rev.	: NC				Material	:	
First Issue	: / / Type : MACHINED PARTS				Due Date	: 16/04/2008	
Previous Run	: 34221				Qty:	20 Um: Each	
Written By	:						
Checked & Approved By	: <u>JL</u> 08.4.02						
Comment	: Est Rev: A New Issue 07-04-23 JLM Est Rev: B updated powder coat per NCR 07.05.16 EC						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B3000X01500	6061-T6 Bar 3" x 1.5"	
	Comment: Qty.: 0.3500 f(s)/Unit Total : 6.9993 f(s) 6061-T6 Bar 3" x 1.5" BATCH: <u>M16530</u>		
2.0	BAND SAW	BAND SAW	
	Comment: BAND SAW Cut blank 4.0" long		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
	Comment: HAAS CNC VERTICAL MACHINING #1		
	1- Mill as per Folio FA684 Rev: <u>A</u> & Dwg D3542 Rev: <u>A</u>		(21)
	2-Deburr per dwg D3443		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	QC8	SECOND CHECK	
	Comment: SECOND CHECK		

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Wednesday, 02/04/2008 11:27:30 AM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 38296

Part Number: D35421

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(21)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BL

08-04-14.

7.0 POWDER COATING

POWDER COATING



(21)

m106442

Comment: POWDER COATING

Powder Coat Grey sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

\*\*\*\*\*ENSURE TO MASK INSIDE BORE\*\*\*\*\*

FL 08/04/15

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(21)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BL 08-04-15

9.0 PACKAGING 1

PACKAGING RESOURCE #1



(21)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 243A

8/4/15

SD

(21)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



08/04/17

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-04-16

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	38296
Description: Bracket	Part Number:	D3542-1
Inspection Dwg: D3542	Rev: A	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	<u>Y.A / </u>	Audited by:	<u>DSP</u>	Prototype Approval:	N/A
Date:	<u>08/04/08</u>	Date:	<u>08/04/08</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.06.13	New Issue	KJ/JLM 	

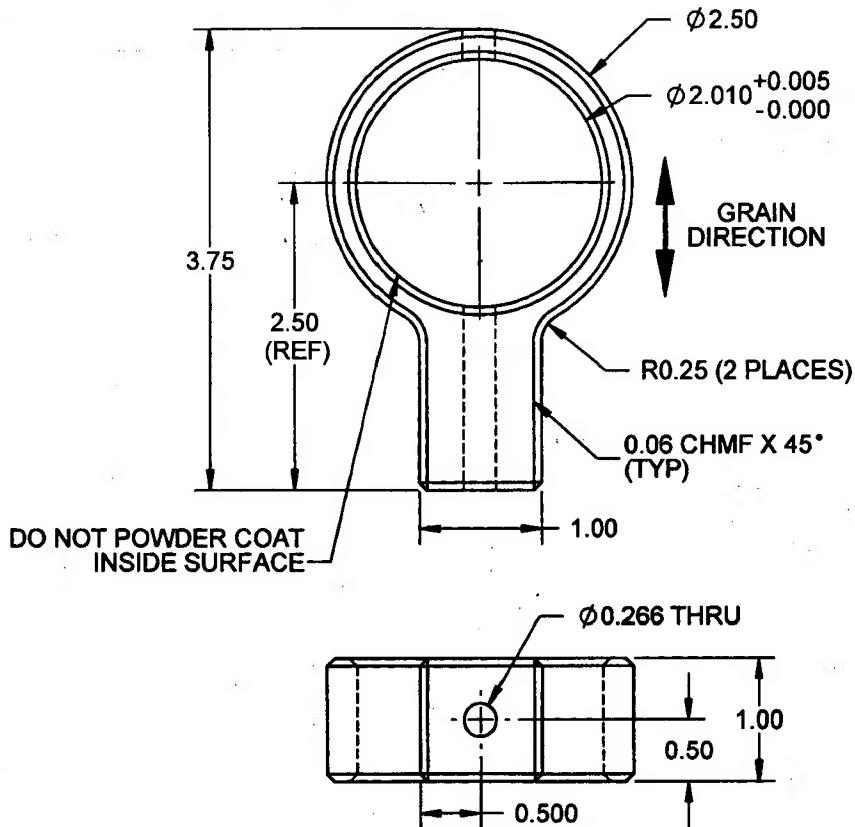
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

H:\FORMS\Quality Assurance\approved QA\FAI revD

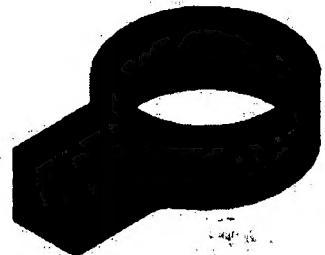
WITHOUT NOTICE  
WORK ORDER  
NO. 382910

**DART**

DESIGN <i>CE</i>	DRAWN BY <i>CE</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>B</i>	APPROVED <i>AA</i>	DRAWING NO. D3542	REV. A	SHEET 1 OF 1
DATE 06.11.27		TITLE BRACKET	SCALE	2:3
REV A	DATE 06.11.27	DESCRIPTION NEW ISSUE		

**RELEASED**  
07.04.02

SHOP COPY  
RETURN TO  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 38296

**D3542-1 BRACKET****NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3 EXCEPT WHERE NOTED
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3542-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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